

Work Order ID: 83647

Printed: 13/04/2012 10:07:49 AM

\*83647\*

Page 1

Item ID: D350-636-011\*

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Reference:

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ

Date: 12/04/12

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Draw Nbr	Revision Nbr
D2750	F
D3492	C

100

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-011 CHG 006

04/12  
S12/04/12

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 83647

\*83647\*

April-23-12 10:07:49 AM

Page 2

Item ID: D350-636-011

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop

\*NS2\*

Start Date: 23/04/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110	Skidtubes	0.00							
*110*	Skidtubes	0.00							
Skidtubes	Memo	0.00							
Skidtubes	1- Pick D2600-3 Bent								
	2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750								
	3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500", deburr.								
	4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting								
	5- Drill only two fwd step holes using DT9616. Ensure proper positioning.								
	6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-1 details). Drill using drill Jig DT8150 & DT8863A for first side only DT8863B for second side (detail B)								
	7- Clecko DT8863B on second side of tube and drill pilot holes for detail B. ***SECOND SIDE***								
	8-Open up holes for Detail B to 0.375" (4 holes per side)and blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750 .Open up holes for ground handling and detail C to 0.500" (8 holes per side)								
	9-Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".								
	10-Open up holes of Detail A to 0.297" (total of 2 holes per side)								

MT 140425

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 83647

April-23-12 10:07:49 AM

\*83647\*

Page 3

Item ID: D350-636-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left  
from bending as per QSI 004

A/R Aluminum Rod batch: A11204 m120854 86 12/04/26  
2010 12-04-26

12-Grind welds flush as per Dwg D2750, \_\_\_\_\_

120

QC10- Inspect visual per QSI004- ground welds

0.00

*S. Zabel-ZC*

\*120\*

QC

Quality Control

Memo

0.00

130

QC5- Inspect part completeness to step on W/O

0.00

*S. Zabel-ZC*

\*130\*

QC

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Work Order ID 83647

\*83647\*

April-23-12 10:07:49 AM

Page 4

Item ID: D350-636-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop

\*NS2\*

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 <b>*140*</b> HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							7/6 12-4-27
150 <b>*150*</b> QC	Memo	0.00							DP 12-5-1
	QC7-Inspect Chemical Conversion Coat	0.00							
	Memo	0.00							

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Work Order ID 83647

\*83647\*

April-23-12 10:07:49 AM

Page 5.

Item ID: D350-636-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop

\*NS2\*

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

160

\*160\*

Skidtubes

Operation  
Description

Skidtubes

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Skidtubes.

Memo

0.00

1-Open up holes of Detail C and ground handling to 0.625" (total of 8 holes per side)  
as per dwg D2750.

2-Open up holes of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3- Open float hole to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D2750  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291 batch: 10/12/11  
exp. date: 13-01-04

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004  
(welding instructions on sheet 8)

A/R Aluminum Rod batch: m120854

9- At section AJ-AJ drill out x-bolt spacer to 0.404".

10-Grind welds flush as per Dwg D2750

3 86 12/05/02  
— a/c/c 12-5-2

04 1205-01

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
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Work Order ID 83647

\*83647\*

April-23-12 10:07:49 AM

Page 6

Item ID: D350-636-011

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop

\*NS2\*

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

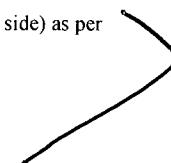
Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

11-Spot face ground handling holes section (total of 4 places per side) as per  
dwg D2750



DR/CC 12-5-2

12-Deburr holes

170

QC10- Inspect visual per QSI004- ground welds

0.00

8/17/05/02

\*170\*

QC

Quality Control

Memo

180

QC5- Inspect part completeness to step on W/O

0.00

8/17/05/02

\*180\*

QC

Quality Control

Memo

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 83647

April-23-12 10:07:49 AM

\*83647\*

Page 7

Item ID: D350-636-011

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Start Date: 23/04/2012 Start Qty: 1.00 \*1\*

Required Date: 07/05/2012 Req'd Qty: 1.00 \*1\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 <b>*190*</b> HandFinish	Pressure Wash per QSI005 4.3	0.00							MG 12-5-3
	Memo	0.00							
	Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.							

200 White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum 0.00

**\*200\***

Powdercoat

Powder Coating

MG 21134

Memo 1:40 0.00  
START TIME: 320°F  
OVEN TEMPERATURE: 320°F  
FINISH TIME: 2:10

ML  
12/5/03

210 QC3- Inspect Part Finish 0.00

**\*210\***

QC

Quality Control

Memo 0.00  
✓ Inspect for foreign object per QSI 024

164 4 12/10/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O: 831647

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D350-6316-011

PAR #: *Super*

Fault Category: Skid tube

NCR: Yes  No  DQA: *Not* Date: 12/06/28Resolution: *Super*Disposition: *Reinspect*

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: 121555

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/06/03	# B1 B2	Found Damin Assembly that D3488-041/42 Do not align with skin tube holes. R.L. tol 1 on D3488-041/042 + HUMAN DRILL (Process)	CP 12/06.04	Drill out 24x5 Aft most holes on SKID to MAX tol Drill out 24x5 holes of D3488 to MAX tol	12-6-0 12/06/04	✓ 12/06/04	CP 12.06.04	<i>121555</i>
			CP 12/06.04	Touch up holes with 1/16" dia As per OS2005 + Re assembly.	12/06/04	12/06/04	CP 12.06.04	<i>121555</i>
				holes were Drilled too large: Script & Do in its P.D.S. Reassembly Replace D3488-041 383407	12/06/04	12/06/04	CP 12.06.04	<i>121555</i>

NOTE: Date &amp; initial all entries

Work Order ID 83647

\*83647\*

April-23-12 10:07:49 AM

Page 9

Item ID: D350-636-011

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

\*240\*

QC

Quality Control

L/L/H/PD 12-06-22

250

Pick Kit

0.00

\*250\*

Packaging

Memo

0.00

*GJK/sse*

260

QC4- 100% Inspect kits for completeness

0.00

\*260\*

QC

Quality Control

Memo

0.00

*S12/06/22*

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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April-23-12 10:07:49 AM

\*83647\*

Page 10

Item ID: D350-636-011

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\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Skidtube LH

Stop

\*NS2\*

Start Date: 23/04/2012 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 07/05/2012 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

270

\*270\*

Packaging

Packaging

0.00

Loc7c

Raw I

IX

SP

Packaging

Memo

Package as per PPP D350-636-011

280

\*280\*

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

12/13/12

MF  
12-06-27

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

April 23 2012 10:07:53 AM

Page 1

Work Order ID: 83647

\*83647\*

Parent Item: D350-636-011

\*D350-636-011\*

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:I 02.09.25 Rearranged procedure steps KJ

IPP Rev:J 06-03-23 As per Rev D JLM

IPP Rev:K 06-07-13 As per ds19343 EC

IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verf:EC

IPP Rev:M 08-04-22 update steps 4, 13 DD verified by:EC

IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec

IPP Rev:O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010

DD verf:EC IPP Rev:P 10.06.22 revise

seq110 DD verf:EC

IPP Rev:Q 10.10.01 as per IIN revH

DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3492-1		Manufactured	No			230	Each	221.0000	8	8	8	12/05/03	SP

\*D3492-1\*

Plug

## Location

FP002 14

69531 8

74444 2

76235 4

FP-A 207

81963 7

83098 ✓ 200

D3492-3

Manufactured

No

230

Each

189.0000

8

8

\*D3492-3\*

Plug

## Location

FP-A 189

81967 5

83099 ✓ 184

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:53 AM

Page 2

Work Order ID: 83647

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

NAS1611-010

Purchased

No

230

Each

247.0000

8

8

\*\*

8

Start Date: 23/04/2012 Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

**\*NAS1611-010\***

O-RING

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	247	
110915	14	
117460	8	
118077	1	
118612	3	
119438	47	
120986	12	
121166	12	
121259	50	
121415	100	

NAS1149D0863J

Purchased

No

250

Each

179.0000

2

2

\*\*

**\*NAS1149D0863J\***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST298	179	
118078	34	
119307	45	
120308	100	

D2744

Manufactured

No

110

Each

30.0000

1

1

\*\*

**\*D2744\***

Cap

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG002	30	
62715	1	
70881	1	
78900	28	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

Page 3

April-23-12 10:07:54 AM

Work Order ID: 83647

**\*83647\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

D2600-3-BENT

Manufactured No

110

Each

30.0000

1

1

\*\*

**\*D2600-3-BFNT\***

Extrusion Bent

*OK 12-04-05*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	30	
66875	7	
73253	1	
75021	1	
75022	1	
75023	1	
81330	4	
82347	3	
83305	12	

D2743

Manufactured No

160

Each

233.0000

8

\*\*

**\*D2743\***

Crossbolt Spacer

*BE 12-05-02*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	-51	
81965	159	
LG001	284	
67766	4	
68251	3	
73403	64	
74445	1	
79517	2	

D2739

Manufactured No

160

Each

3.0000

1

\*\*

**\*D2739\***

350 I Beam

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	3	
72155	1	
81508	1	
82124	1	

*B 43 444**OK 9/11 12-05-01*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Picklist Print**

April-23-12, 10:07:54 AM

Page 4

**Work Order ID:** 83647**\*83647\*****Parent Item:** D350-636-011**\*D350-636-011\*****Parent Item Name:** Skidtube LH**Start Date:** 23/04/2012**Required Date:** 07/05/2012**Start Qty:** 1.00**Required Qty:** 1.00

D3490-3

Manufactured No

160

Each

46.0000

4

4

**\*\*****\*D3490-3\***

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	44	
82016	44	
LG001	2	
78800	2	

D3490-1

Manufactured No

160

Each

64.0000

4

4

**\*\*****\*D3490-1\***

Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	55	
81976	55	
LG001	9	
62450	2	
74875	4	
77042	3	

ALS4-1032-225

Purchased No

220

Each

1,850.000

38

38

**\*\*****\*AI S4-1032-225\***

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST281	1827	
108696	146	
110768	62	
118386	55	
118966	68	
121269✓	1496	
ST282	23	
120410	10	
120451	13	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:54 AM

Page 5

Work Order ID: 83647

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*83647\***  
**\*D350-636-011\***

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230

Each

17.0000

1

1

\*\*

1

*(RP)**12/05/03***\*D3793-3\***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	17	
80434	6	
82166 ✓	11	

AN8C35A

Purchased No

230

Each

90.0000

1

1

\*\*

1

*(RP)**14/05/03***\*AN8C35A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002	89	
115960	1	
118286 ✓	38	
121275	50	
ST346	1	
114442	0	
115188	0	
115960	1	

D3793-1

Manufactured No

230

Each

13.0000

1

1

\*\*

1

*(RP)**12/05/03***\*D3793-1\***

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	13	
82171 ✓	13	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:54 AM

Page 6

**Work Order ID:** 83647**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH**\*83647\***  
**\*D350-636-011\*****Start Date:** 23/04/2012**Required Date:** 07/05/2012**Start Qty:** 1.00**Required Qty:** 1.00

D3488-041

Manufactured No

230

Each

3.0000

1

1

\*\*

1 (2P) 12/05/03

**\*D3488-041\***

Blade Fitting Assembly, LH

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002 82271	3	
61689	1	
75056	1	
77021	1	

D3794-3

Manufactured No

83407✓

230

Each

10.0000

1

1

\*\*

1 (2P) 12/05/03

**\*D3794-3\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP002 83396	10	
74530	2	
80436	8	

AN6C44A

Purchased No

230

Each

168.0000

4

4

\*\*

4 (2P) 12/05/03

**\*AN6C44A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	2	
103964	2	
ST343	166	
120143	5	
121013	11	
121167✓	100	
121440	50	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:55 AM

Page 7

Work Order ID: 83647

**\*83647\***

Parent Item: D350-636-011

**\*D350-636-011\***

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased No

230 Each 110.0000

1 1

\*\*

1

(28)

12/05/03

**\*MS21083C8\***

NUT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
304	100	
121185✓	50	
121349	50	
FP002	1	
115884	1	
ST303	4	
115884	0	
118077	1	
119309	2	
119638	1	
ST304	5	
121011	5	

D3536-25

Manufactured No

230 Each 9.0000

1 1

\*\*

1

(28)

12/05/03

**\*D3536-25\***

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP 83391✓	9	
81342	9	

D3631-1

Manufactured No

230 Each 115.0000

8 8

\*\*

8

(28)

12/05/03

**\*D3631-1\***

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	100	
81874 ✓	100	
ST072	15	
68062	2	
75548	13	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

# Picklist Print

April-23-12 10:07:55 AM

Page 8

Work Order ID: 83647

\*83647\*  
\*D350-636-011\*

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3791-1

Manufactured No

230

Each

12.0000

1

1

\*\*

1

(2P)

12/05/03

\*D3791-1\*

Wearplate

Location	Loc Qty	Loc Code
FP002	83392 ✓	12
62239	2	
82168	10	

AN960C10L

NAS1149C0332 ✓ Purchased

No

230

Each

0.0000

38

38

\*\*

38

(2P)

12/05/03

\*AN960C10L \*

washer

D2745

Manufactured No

230

Each

36.0000

8

8

\*\*

8

(2P)

12/05/03

\*D2745\*

Bushing

Location	Loc Qty	Loc Code
FP	6	
79518	6	
FP001	30	
69529	1	
76142	1	
81964 ✓	28	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

April-23-12, 10:07:55 AM

Page 9

**\*83647\***  
**\*D350-636-011\***

**Work Order ID:** 83647**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH**Start Date:** 23/04/2012**Required Date:** 07/05/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN3C5A

Purchased No

230 Each 1,642.000 34 34

\*\*

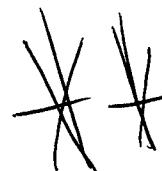
34

(28)

12/05/03

**\*AN3C5A\***

Bolt



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001 121068✓	7	27
115835	7	
ST350	1635	27
116419	28	
117343	13	
117764	7	
117872	2	
119749	23	
120423	62	
1210168	500	
121255	500	
121444 ✓	500	7

D3537-1

Manufactured No

230 Each 17.0000 3 3

\*\*

3

(28)

12/05/03

**\*D3537-1\***

Wearpad

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG 81959✓	10	
79833	10	
FP002	7	
69817	5	
73716	2	

NAS1149C0832R

Purchased No

230 Each 279.0000 1 1

\*\*

1

(28)

12/05/03

**\*NAS1149C0832R\***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST297	279	
114915 ✓	279	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:55 AM

Page 10

**Work Order ID:** 83647**Parent Item:** D350-636-011**Parent Item Name:** Skidtube LH**\*83647\***  
**\*D350-636-011\*****Start Date:** 23/04/2012**Required Date:** 07/05/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN3C6A

Purchased

No

230

Each

425.0000

4

4

\*\*

4

**\*AN3C6A\***

BOLT

 12/05/03Location      Loc Qty      Loc Code

FP001	1	
111982	1	
ST351	424	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	332	

NAS1611-013

Purchased

No

230

Each

154.0000

8

8

\*\*

8

**\*NAS1611-013\***

O-RING

 12/05/03Location      Loc Qty      Loc Code

FP001	154	
116582	5	
117291	2	
117887	53	
119623	36	
121166	8	
121259	50	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:55 AM

Page 11

Work Order ID: 83647

**\*83647\***  
**\*D350-636-011\***

Parent Item: D350-636-011  
Parent Item Name: Skidtube LHStart Date: 23/04/2012  
Start Qty: 1.00Required Date: 07/05/2012  
Required Qty: 1.00

D3535-25

Manufactured No

230 Each 26.0000

1 1

\*\*

**\*D3535-25\***

Wearshoe

(SP)

12/03/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	26	
62233	1	
81357	8	
82156	17	

D3794-1

Manufactured No

230 Each 26.0000

1 1

\*\*

**\*D3794-1\***

Gasket

(SP)

12/05/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	23	
82167	23	
FP002	3	
75042	2	
80435	1	

MS21043-6

Purchased No

230 Each 710.0000

4 4

\*\*

**\*MS21043-6\***

NUT

(SP)

12/05/03

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	20	
103693	20	
ST301	690	
117887	6	
118384	184	
120308	500	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date &amp; initial all entries

**Picklist Print**

\* April-23-12 10:07:56 AM

Page 12

Work Order ID: 83647

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*83647\***  
**\*D350-636-011\***

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

**\*D3493-1\***  
Washer

Manufactured	No	250	Each	55.0000	2	2
--------------	----	-----	------	---------	---	---

\*\*

83647  
Ed

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST050	55	_____
70697	2	_____
77573	1	_____
78835	11	_____
82023	41	_____

MS21083C8

**\*MS21083C8\***  
NUT

Purchased	No	250	Each	110.0000	2	2
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\*\*

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

304	100	_____
121185	50	_____
121349	50	_____
FP002	1	_____
115884	1	_____
ST303	4	_____
115884	0	_____
118077	1	_____
119309	2	_____
119638	1	_____
ST304	5	_____
121011	5	_____

4/26/09  
Ed

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:56 AM

Page 13

Work Order ID: 83647

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*83647\***  
**\*D350-636-011\***

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C21A

Purchased No

250

Each

89.0000

2

2

\*\*

**\*AN8C21A\***  
BOLT

NAS1515H3L

Purchased No

230

Each

134.0000

4

4

\*\*

**\*NAS1515H3I \***

WASHER

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST343	89	
118758	3	
121067	16	
121167	20	
121275	50	

M/21/295

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	40	
102472	40	
ST277	94	
118686	3	
119438	1	
120360	40	
121243 ✓	50	

4  
12/05/03

D2741

Manufactured No

250

Each

41.0000

1

1

\*\*

**\*D2741\***  
Blade, 350 Skidtube

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST	-10	
ST466	51	
71856	1	
76984	2	
79516	38	

83/35/04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Picklist Print**

April-23-12 10:07:56 AM

Page 14

Work Order ID: 83647

Parent Item: D350-636-011

Parent Item Name: Skidtube LH

**\*83647\***  
**\*D350-636-011\***

Start Date: 23/04/2012

Required Date: 07/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3532-1

**\*D3532-1\***  
Spacer

Manufactured No

250

Each

29.0000

2

2

\*\*

83647  
L14/07/12

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST053	29	
78839	5	
82041	24	

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	88647
Description: Blade PATTING	Part Number:	3488-041
Inspection Dwg: 3488 Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

SC1AB

SG 104170

Measured by:		Audited by:		Prototype Approval:	N/A
Date:	12-06-11	Date:		Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
X				D2750-042	350 SKIDTUBE ASSEMBLY, RH
	X			D2750-043	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4		4	D3490-3	SPACER
8	8	8	8	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8	8	8	D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-26	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

## GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:  
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ( $\phi$ 0.297) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.  
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL.
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL.

SHOP COPY  
RETURN TO  
ENGINEERING  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 83647 MCJ  
12/04/23

RELEASED  
08-07-16

F	INCORPORATE DS9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/3 REPLACES D3535-13/35 (ZN C8-1); D3794-1/3 REPLACES D3536-13/35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/WAFT SADDLE REMOVED (8) WASHERS; WEARPLATE QTY UPDATED (ZN B8-1); D3488-041/042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCH 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD (8) WASHERS; WEARPLATE QTY UPDATED (ZN C8-1); ADD D3631-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/WAFT SADDLE REMOVED (8) WASHERS; WEARPLATE QTY UPDATED (ZN B8-1); REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SLOTS FOR APICAL FLOATS; INCORPORATE DEO 9139/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE USA, INC.	
DRAWN	<i>PH</i>	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.	<i>AP</i>	D2750	SHEET 1 OF 11
APPROVED	<i>AP</i>	TITLE	SCALE
DE APPR.	<i>AP</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

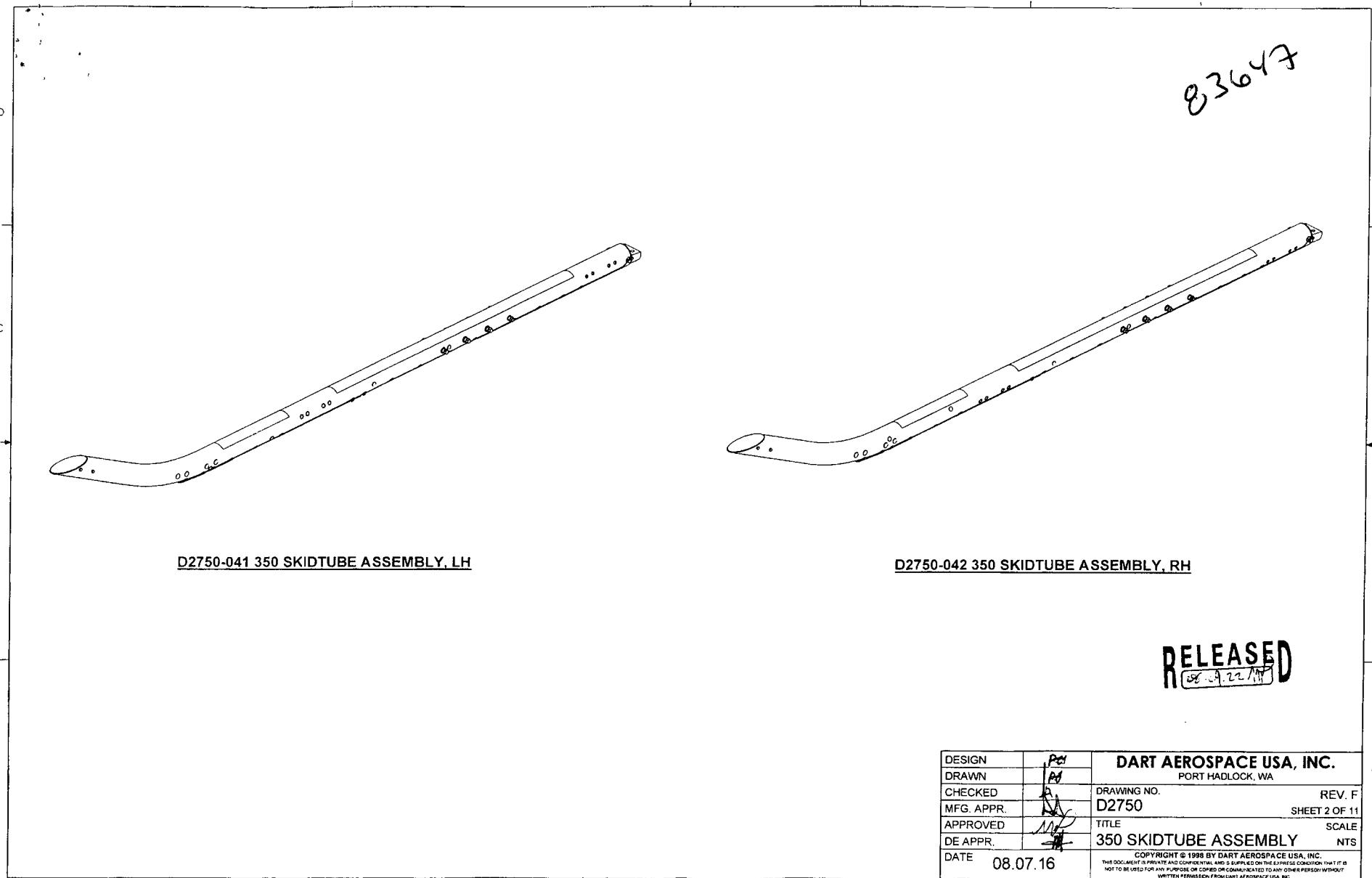
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



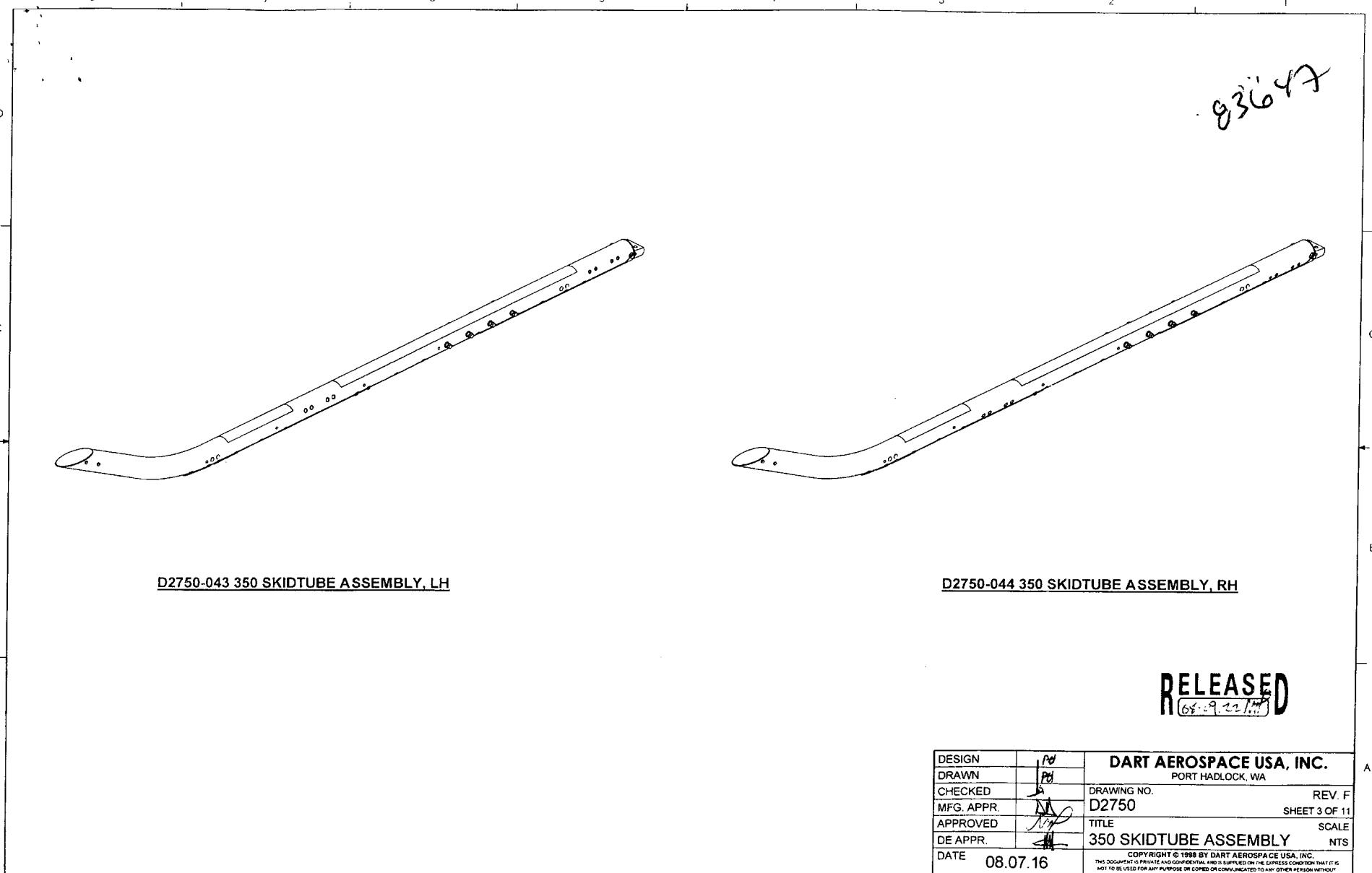
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

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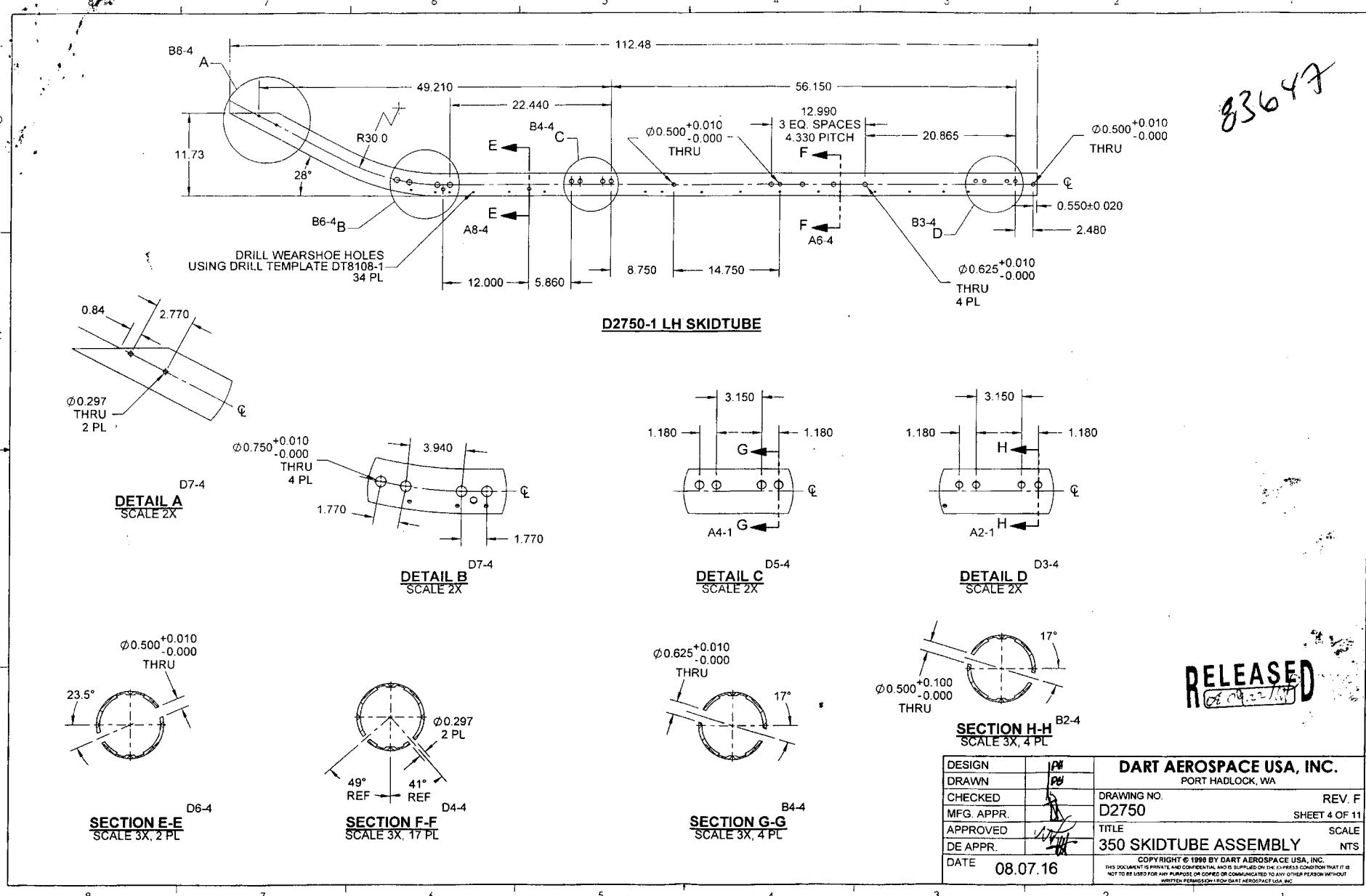
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NOTE: Date & initial all entries



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MFG. APPR.	
APPROVED	
DE APPR.	
DATE	08.07.16

**DART AEROSPACE USA, INC.**  
PORT HADLOCK, WA

DRAWING NO. D2750 REV. F  
SHEET 4 OF 11

TITLE 350 SKIDTUBE ASSEMBLY NTS

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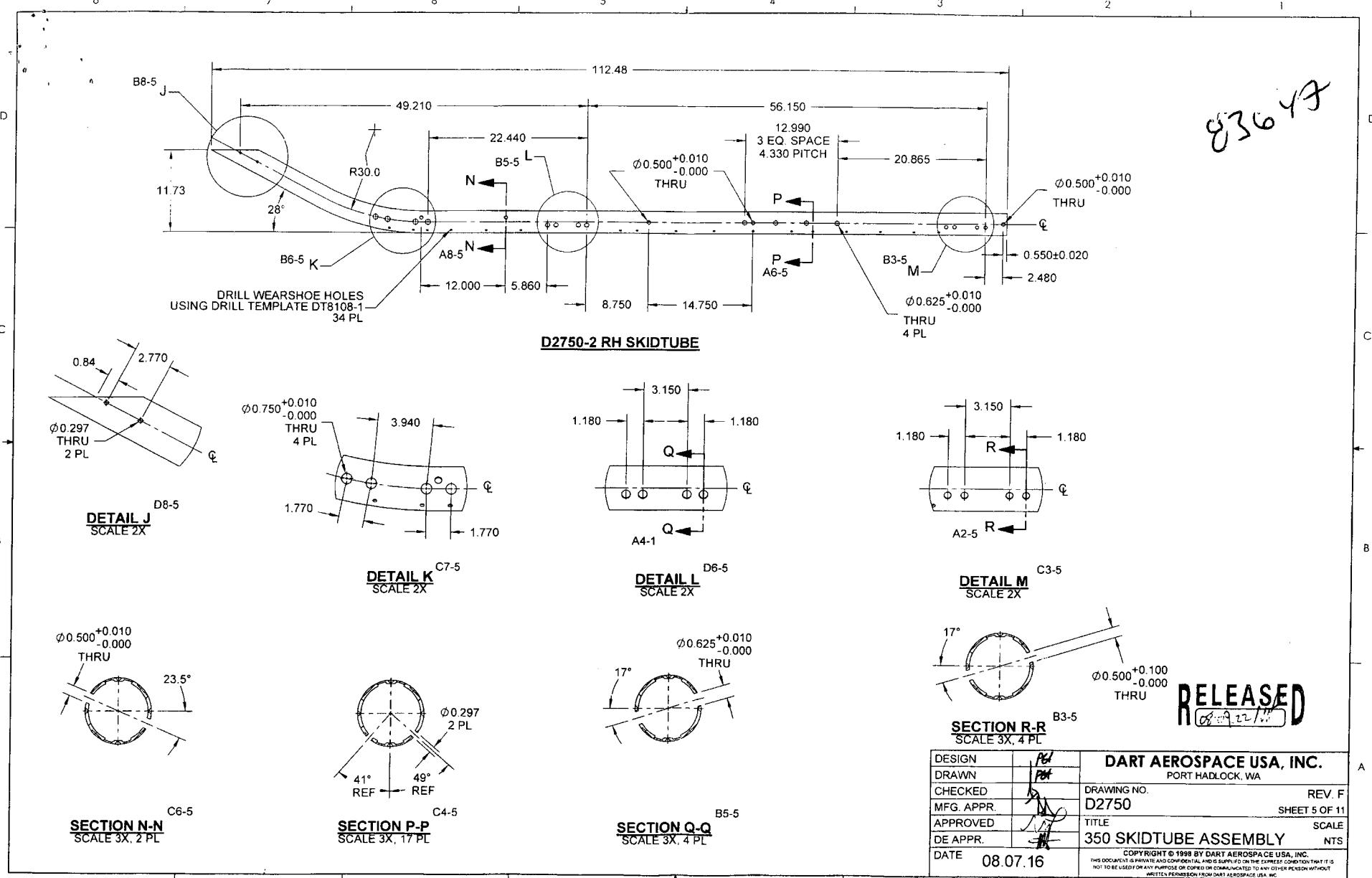
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



83648

RELEASED  
08-09-11

**SECTION N-N**  
SCALE 3X, 2 PL

C4-5

**SECTION Q-Q**  
SCALE 3X. 4 PL

DRAWN	<i>PSA</i>	PORT HADLOCK, WA	
CHECKED	<i>PSA</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>PSA</i>	D2750	SHEET 5 OF 11
APPROVED	<i>PSA</i>	TITLE	SCALE
DE APPR.	<i>PSA</i>	350 SKIDTUBE ASSEMBLY NTS	
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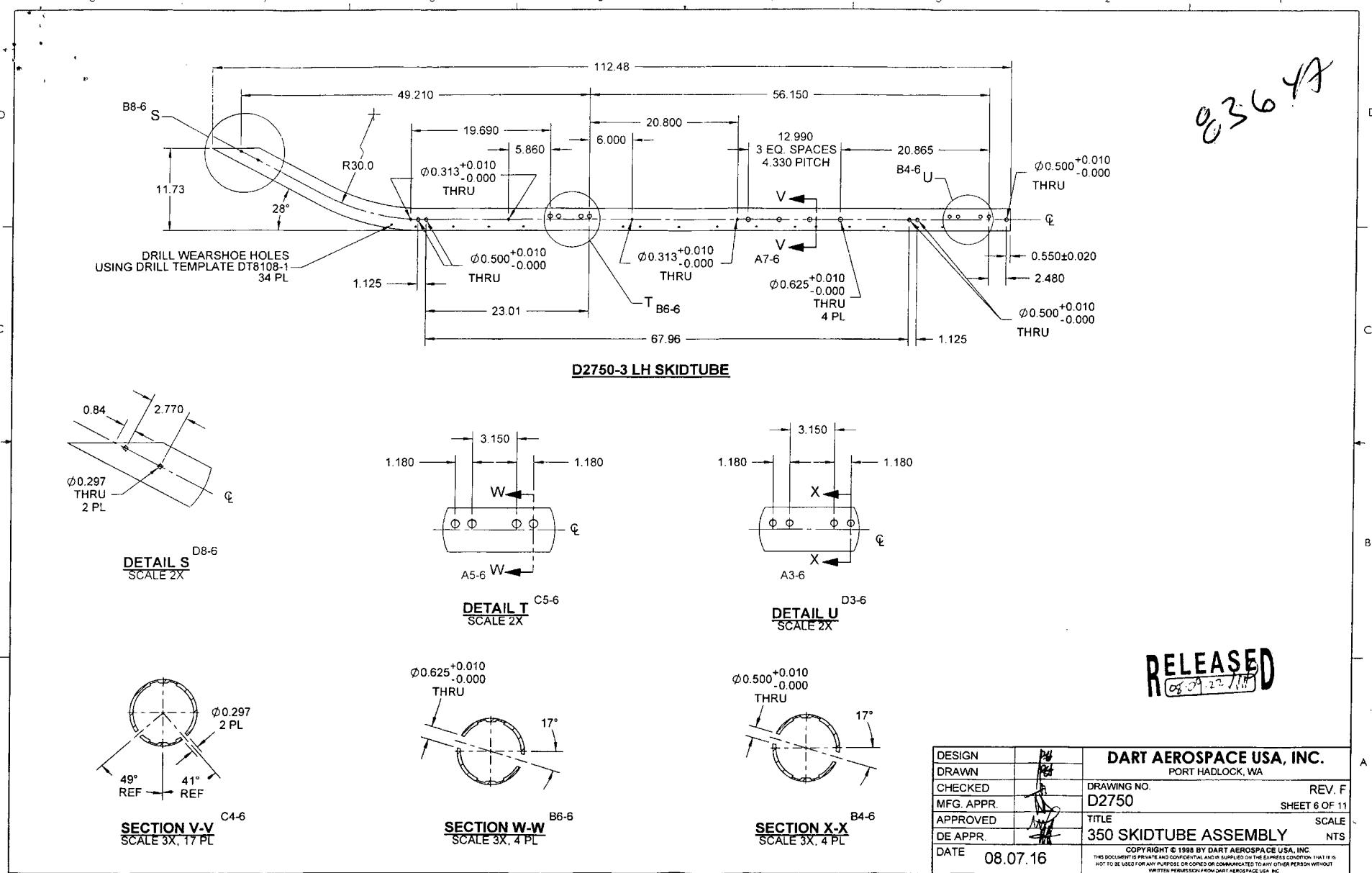
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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803648

RELEASED  
06-09-22 JH

DESIGN	<i>PH</i>	<b>DART AEROSPACE USA, INC.</b>		
DRAWN	<i>PS</i>	PORT HADLOCK, WA		
CHECKED	<i>AS</i>	DRAWING NO.	REV. F	
MFG. APPR.	<i>AS</i>	D2750	SHEET 6 OF 11	
APPROVED	<i>AS</i>	TITLE	SCALE	
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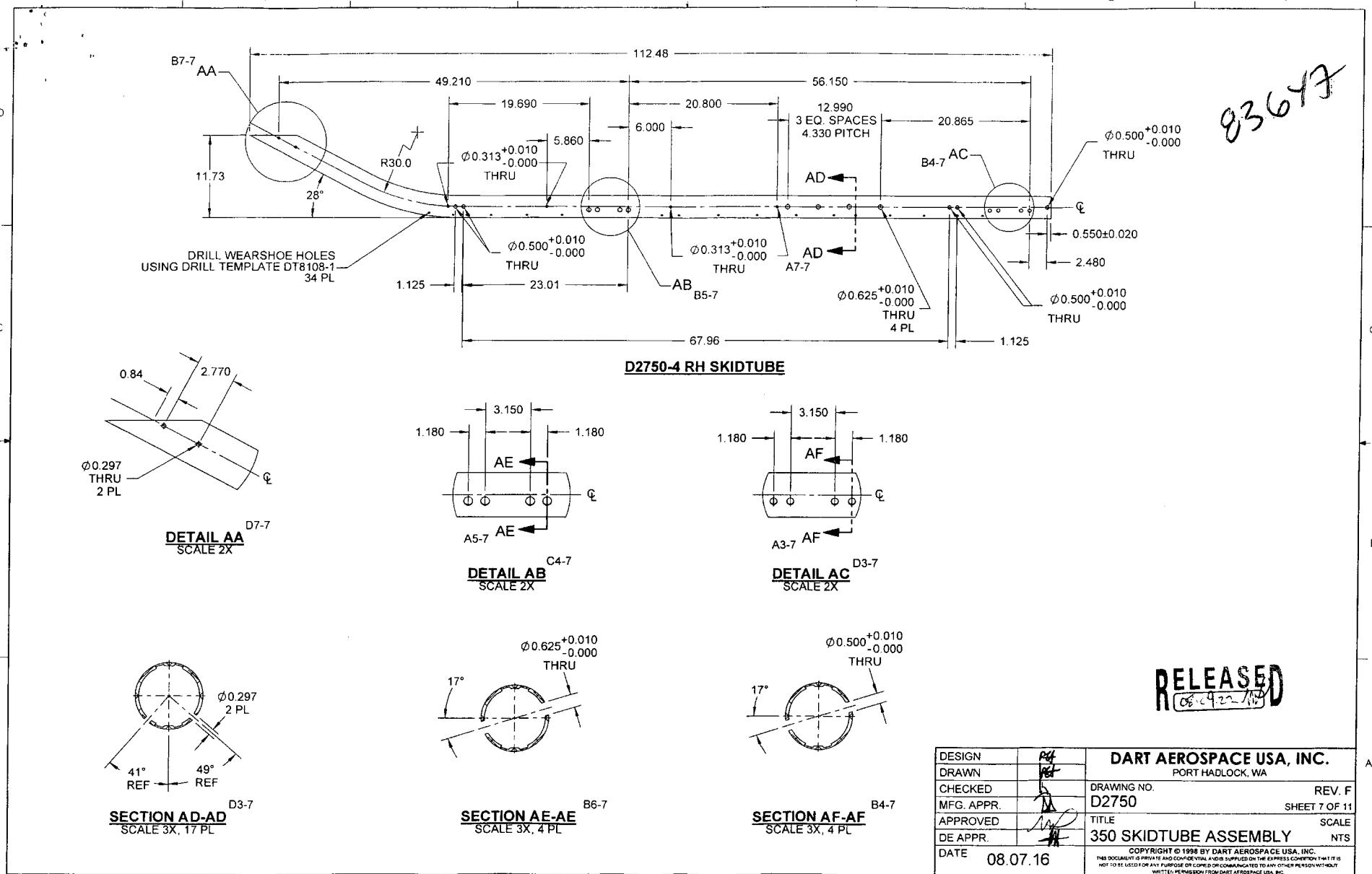
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DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



g3647

RELEASED  
06-09-2014

DESIGN	PS4	DART AEROSPACE USA, INC.		
DRAWN	PS4	PORT HADLOCK, WA		
CHECKED	PS4	DRAWING NO.	REV. F	
MFG. APPR.	PS4	D2750	SHEET 7 OF 11	
APPROVED	PS4	TITLE	SCALE	
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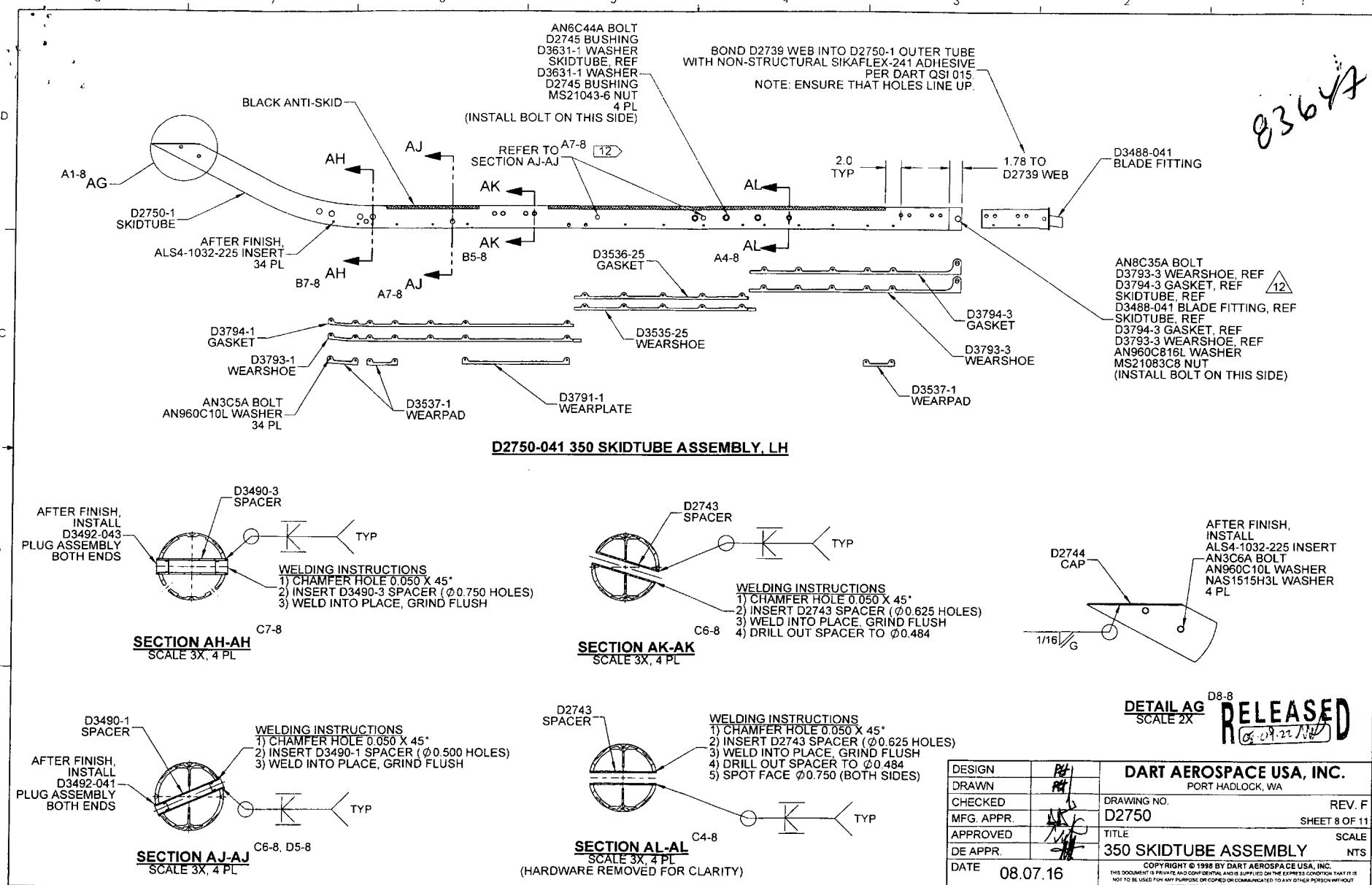
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DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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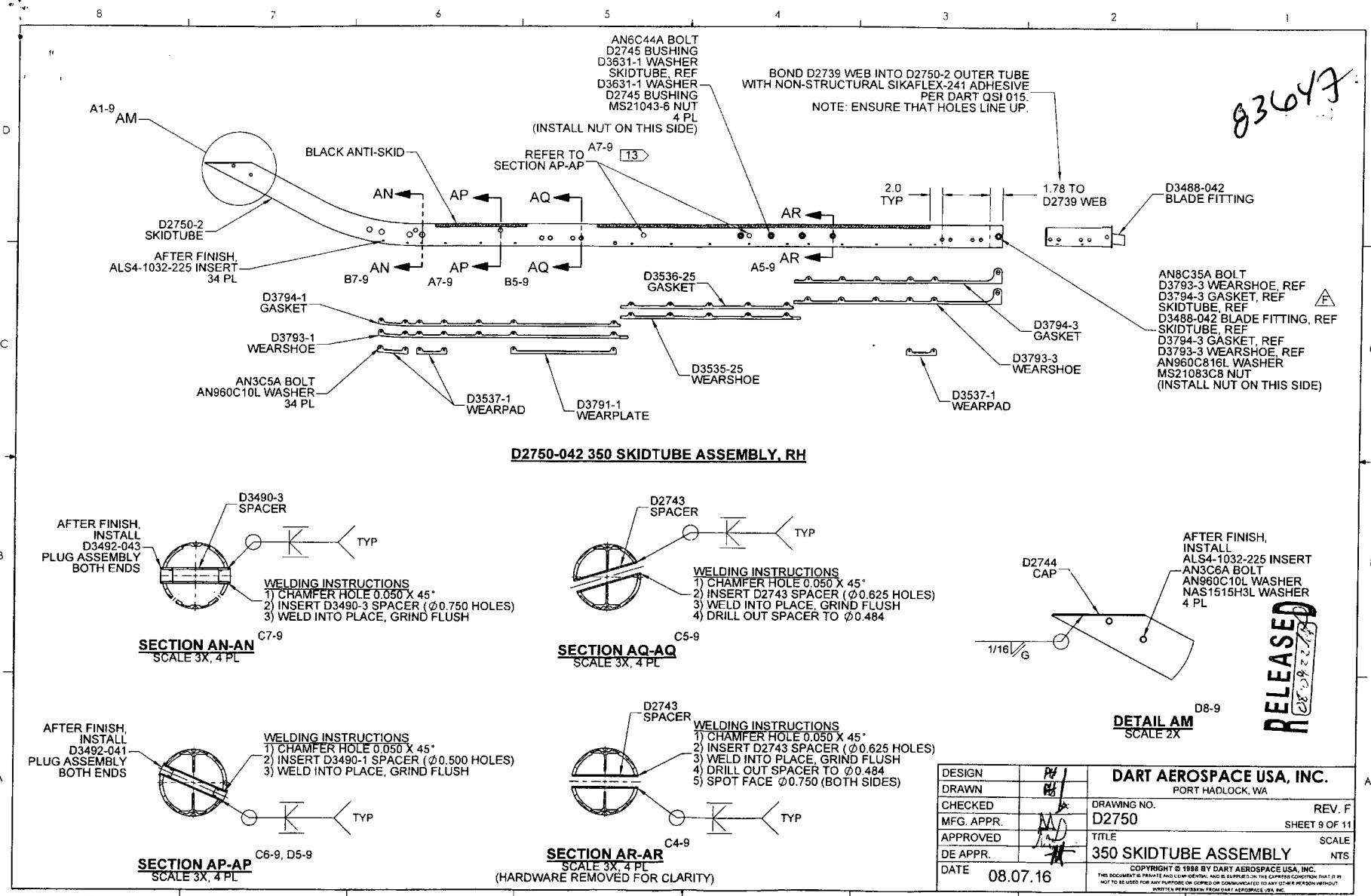
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



3647

D3793-5 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-042 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS21083C8 NUT  
(INSTALL NUT ON THIS SIDE)

RELEASER  
2022-04-27  
2022-04-27  
2022-04-27

DESIGN	PF	DART AEROSPACE USA, INC.		
DRAWN	PF	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. F	
MFG. APPR.	MD	D2750	SHEET 9 OF 11	
APPROVED	AA	TITLE	SCALE	
DE APPR.	AA	350 SKIRTUBE ASSEMBLY	NTS	
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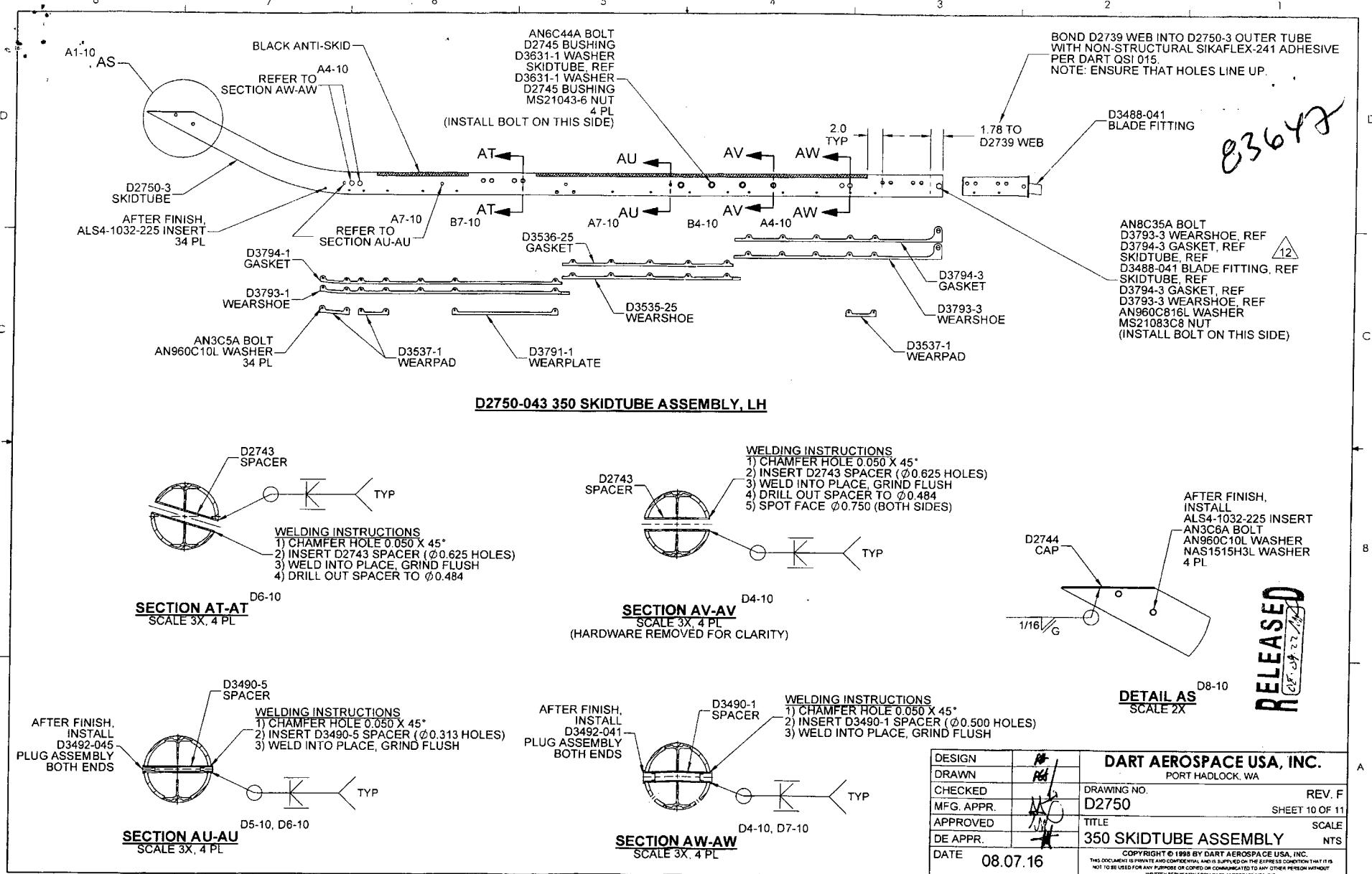
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DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

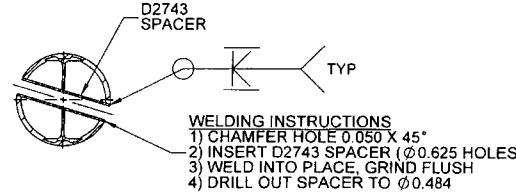
NOTE: Date & initial all entries



BOND D2739 WEB INTO D2750-3 OUTER TUBE  
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE  
PER DART QSI 015.  
NOTE: ENSURE THAT HOLES LINE UP.

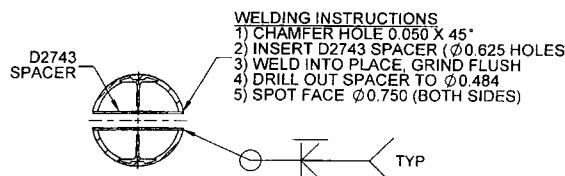
AN8C35A BOLT  
D3793-3 WEARSHOE, REF  
D3794-3 GASKET, REF  
SKIDTUBE, REF  
D3488-04 BLADE FITTING, REF  
SKIDTUBE, REF  
D3794-3 GASKET, REF  
D3793-3 WEARSHOE, REF  
AN960C816L WASHER  
MS2108C38 NUT  
(INSTALL BOLT ON THIS SIDE)

**D2750-043 350 SKIDTUBE ASSEMBLY, LH**

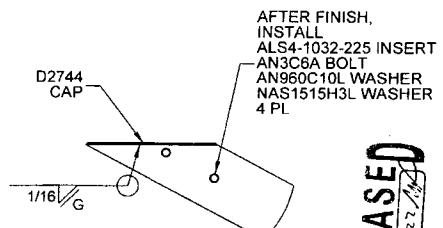


**SECTION AT-A**  
SCALE 3Y 1 PI

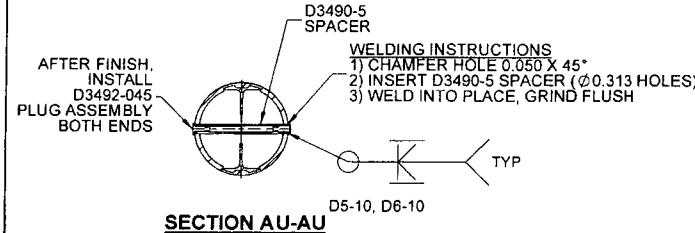
SCALE 3X, 4 PL



D4-10  
**SECTION AV-AV**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)

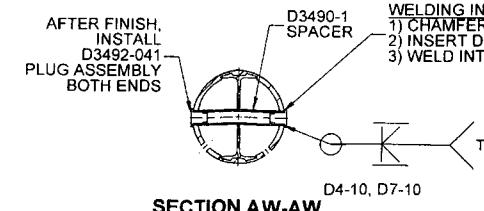


**DETAIL AS** D8-10  
**SCALE 2X**



**SECTION AU-AU**

SCALE 3X. 4 PL



**SECTION AW-AW**

DESIGN	<u>10</u>	DART AEROSPACE USA, INC.		
DRAWN	<u>Rev 1</u>	PORT HADLOCK, WA		
CHECKED		DRAWING NO.	REV. F	
MFG. APPR.	<u>NO</u>	D2750	SHEET 10 OF 11	
APPROVED	<u>NO</u>	TITLE	SCALE	
DE APPR.	<u>-</u>	350 SKIDTUBE ASSEMBLY		NTS
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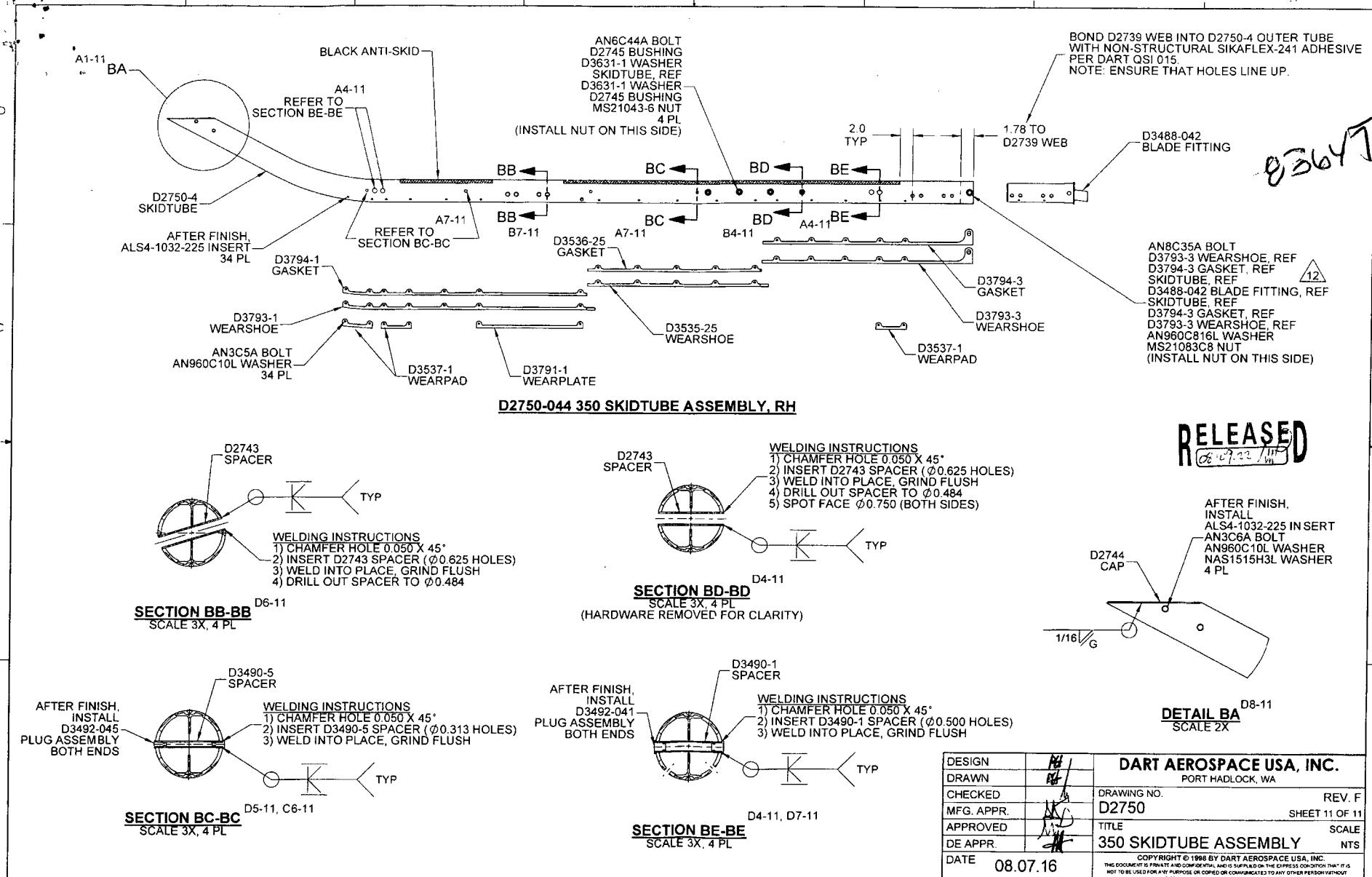
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries



DESIGN	<i>AB</i>	
DRAWN	<i>AB</i>	
CHECKED	<i>AB</i>	
MFG. APPR.	<i>AB</i>	
APPROVED	<i>AB</i>	
DE APPR.	<i>AB</i>	
DATE	08.07.16	
DRAWING NO.	D2750	REV. F
TITLE	350 SKIDTUBE ASSEMBLY	SCALE NTS
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W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

NO. 293

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliott  
Job number: 82796  
Part number: A350-636-014  
Description: Skid tube  
Welding Process: Tig[] Mig[]  
Base material: Alum  
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]  
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]  
Undercut: pass[] fail[]  
Pin holes: pass[] fail[]  
Overlap (cold lap): pass[] fail[]  
Porosity (surface): pass[] fail[]  
Coloration: pass[] fail[]

Qualifier Barclay Elliott Date of Test Coupon 12-05-01  
Welder Barclay Elliott Date of Test Coupon 12-05-01

The above named individual is qualified in accordance with AWS D17.1.2001 to weld